

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029542**Date Inspected:** 19-Apr-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Jobsite**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

At the start of shift, this Quality Assurance Inspector (QAI) traveled to the project site and observed the work and the inspection performed by American Bridge/Fluor Enterprises (AB/F) personnel. The inspection was performed on the various Complete Joint Penetration (CJP) groove welds of the East and West Orthotropic Box Girders (OBG's).

The welding was performed utilizing Shielded Metal Arc Welding (SMAW) process as per the Welding Procedure Specifications (WPS's).

This QAI witnessed AB/F QC William Sherwood perform preliminary Magnetic Particle Testing (MPT) of the seal cover plate welds at 12-E-PP119(+1500)-E3. This QAI noticed a linear MT indication emerge during the QC testing. The indication measured 4 inches long vertically and 2 inches long horizontally with the corner wrap and/or intersection connecting these lengths. This QAI also noted several visual deficiencies among the welds including excessive reinforcement and convexity. This MT performed by the AB/F QC was being performed prior to the required waiting period for final inspections.

This QAI witnessed welding of 2-1/2 inch diameter schedule 40 domestic water pipe to flange for 3-2.5.PP8-NW. The welding was performed by Rick Kickvee #5319 utilizing E6010 electrodes for root pass and E7018 electrodes for fill and cap passes as per WPS #1-12-1. AB/F QC Fred Michels was present.

**Summary of Conversations:**

No significant conversations took place.

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## WELDING INSPECTION REPORT

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### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Morris, Monty
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Quality Assurance Inspector
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<b>Reviewed By:</b>	Reyes, Danny
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QA Reviewer
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